

Date: Tuesday, 7/10/2007 1:05:48 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HINGE BRACKET
Job Number : 33453
Estimate Number : 10347
P.O. Number : N/A Part Number : D28572
This Issue : 7/10/2007 S.O. No. : N/A Drawing Number : D2857 REV B
Prsht Rev. : NC Project Number : N/A
First Issue : N/A Type : MACHINED PARTS Drawing Revision : B
Previous Run : 31791 Material : N/A
Due Date : 7/23/2007 Qty: 24 Um: Each
Written By :
Checked & Approved By : J. 07.07.10
Comment : Est C 00.06.22 Removed P/O for powder coat EC
Est D 06.03.30 Added level 8 EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B2000X01250 6061-T6 Bar 2.0" x 1.25"



Comment: Qty.: 0.4594 f(s)/Unit Total : 11.0250 f(s)
Material: 2.00" X 1.25"
6061-T6 (QQ-A-225/8 or QQ-A-250/11 or QQ-A-200/8)
(M6061T6B200001250)
Batch M105225

2.0 BAND SAW BAND SAW



Comment: BAND SAW
Cut blanks 5.2"

J.L. 07/09/02

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
Machine per folio D2857-2

P/O

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 07/09/05 J.L. 07/09/02
27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2857-2 PAR #: N/A Fault Category: Prod / Machined Parts NCR: Yes No DQA: Yes Date: 07/09/10
 QA: N/C Closed: Yes Date: 07.09.10

NCR: <u>33453</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/09/05	30 ①	One part is scrap because I put the wrong way on the vise. R.C. operator error	<i>[Signature]</i> 05/09/05	Scrap and Destroy and replace No replace.	<i>[Signature]</i> 07/09/05	<i>[Signature]</i> 07/09/05	<i>[Signature]</i> 05/09/05	<i>[Signature]</i> 07/09/05
07/09/06	②	Second part I move. The Y origin not the good way so the hole of .176 is offset. R.C. operator error.	<i>[Signature]</i> 05/09/06	Scrap. No replace	<i>[Signature]</i> 07/09/06	<i>[Signature]</i> 07/09/06	<i>[Signature]</i> 05/09/06	<i>[Signature]</i> 07/09/06

NOTE: Date & initial all entries

Date: Tuesday, 7/10/2007 1:05:48 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET

Job Number: 33453

Part Number: D28572

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SL 07.09.06 (22)

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble

2-Deburr any rough edges after tumbling

SL 07/09/06 (22)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.3

ML 07 09 06

2

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-L 07/09/07 (22x)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) per Dart QSI 005 4.3

BK 07-09-07

(22)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

SL 07/09/10 (22)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

SL 07/09/10 (22)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SL 07/09/10 (22)

Job Completion



U 070910

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	33453
Description: Hinge Bracket		Part Number:	D2857-2
Inspection Dwg: D2857 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

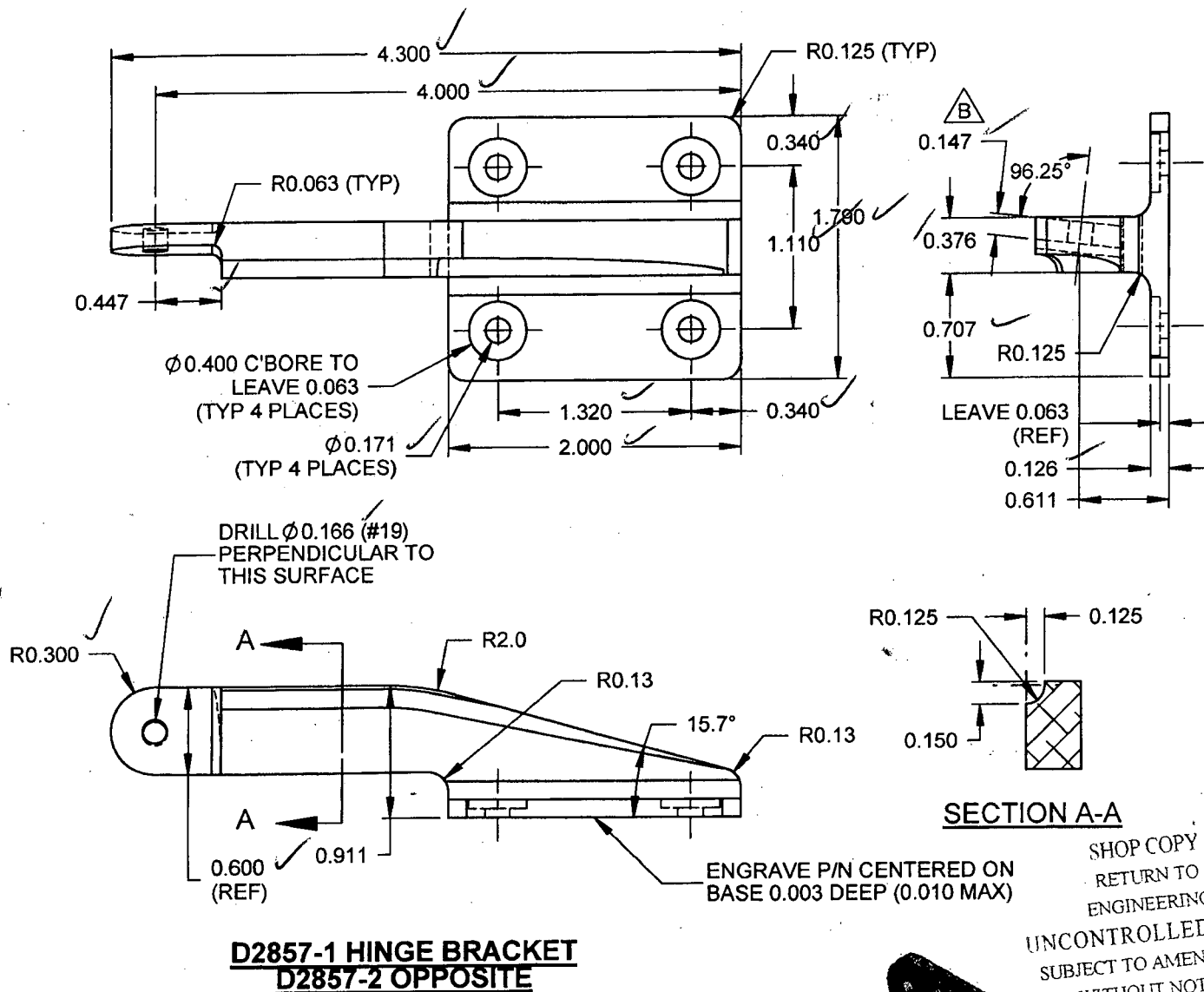
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.300	+/-0.010	4.300	✓			
4.000	+/-0.010	4.003	✓			
0.340	+/-0.010	.341				
1.110	+/-0.005	1.108	✓			
1.790	+/-0.010	1.796				
1.320	+/-0.005	1.319				
2.000	+/-0.010	2.005				
0.340	+/-0.010	.342				
0.447	+/-0.010	.448				
Ø0.171	+0.005/-0.000	.173				
0.147	+/-0.010	.154				
0.376	+/-0.010	.379				
0.126	+/-0.010	.129				
0.063	+/-0.010	.063				
Ø0.166	+0.005/-0.000	.166				
0.911	+/-0.010	.911				
0.600	+/-0.010	.607				
0.125	+/-0.010	.125				
0.150	+/-0.010	.150				

Measured by:	Audited by:	Prototype Approval:	
Date:	Date:	Date:	

Rev	Date	Change	Revised by	Approved
A	04.06.15	New Issue	KJ/JLM	
B	07.04.20	Dimensions update per Dwg Rev B	KJ/JLM	

DART

DESIGN KE	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2857	REV. B SHEET 1 OF 1
DATE 06.08.28	TITLE HINGE BRACKET		SCALE 1:1
REV	DATE	DESCRIPTION	
A	98.12.14	NEW ISSUE	
B	06.08.28	ADD THICKNESS, REDRAW W/ SOLIDWORKS	

RELEASED
06.10.13**NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM BAR PER QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX

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33453